

# Work Order ID 60928

July 27, 2010 8:27:44 AM



Page 1

Item ID: D2195-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 7/27/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2195

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2195 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Deburr if necessary

364 . 063

1310-7-27

*[Signature]*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1310-7-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*S. Davis/28*

*(x4)*

-1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60928

July 27, 2010 8:27:45 AM



Page 2

Item ID: D2195-1

Revision ID:

Item Name: Bracket

Start Date: 7/27/10

Required Date: 7/30/10

Reference:

Start Qty: 4.00

Req'd Qty: 4.00

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per dwg D2195

0.00

0.00

8/10/07/28

(4)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/07/28

(40)

7

150



Packaging

Packaging

Identify as per dwg & Stock Location: 008

Memo

0.00

0.00

8/10/07/28 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60928**

July 27, 2010 8:27:45 AM



Page 3

Item ID: D2195-1

Revision ID:

Item Name: Bracket

Start Date: 7/27/10

Start Qty: 4.00

Required Date: 7/30/10

Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/29

H 10-7-28  
(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 27, 2010 8:29:19 AM

Page 1

Work Order ID: 60928

Parent Item: D2195-1

Parent Item Name: Bracket






Start Date: 7/27/10

Start Qty: 4.00

Required Date: 7/30/10

Required Qty: 4.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd  
IPP Rev:B 09-01-28 rev.d as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No				sf	19.8267	0.211	0.87		1.1	
											PB10-7-27		
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT		19.82669474					
						111323		0					
						114799		19.8266947					
										114799			

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 60928
<b>Description:</b> BRACKET		<b>Part Number:</b> D2195-2
<b>Inspection Dwg:</b> D2195 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.131	✓		V 1302	
Ø .203	+ .005 - .001	.205	✓		V	
Ø .257	+ .006 - .001	.260	✓		V	
.375	± .010	.375	✓		V	
1.200	± .010	1.202	✓		V	
2.390	± .010	2.390	✓		V	
5.890	± .010	5.890	✓		V	
7.090	± .010	7.092	✓		V	
7.590	± .010	7.595	✓		V	
4.140	± .010	4.142	✓		V	
.336	± .010	.333	✓		V	
1.273	± .010	1.275	✓		V	
2.211	± .010	2.209	✓		V	
3.149	± .010	3.149	✓		V	
3.524	± .010	3.522	✓		V	
.063	± .010	.060	✓		V	

<b>Measured by:</b>	IB
<b>Date:</b>	10-7-27

<b>Audited by:</b>	
<b>Date:</b>	

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

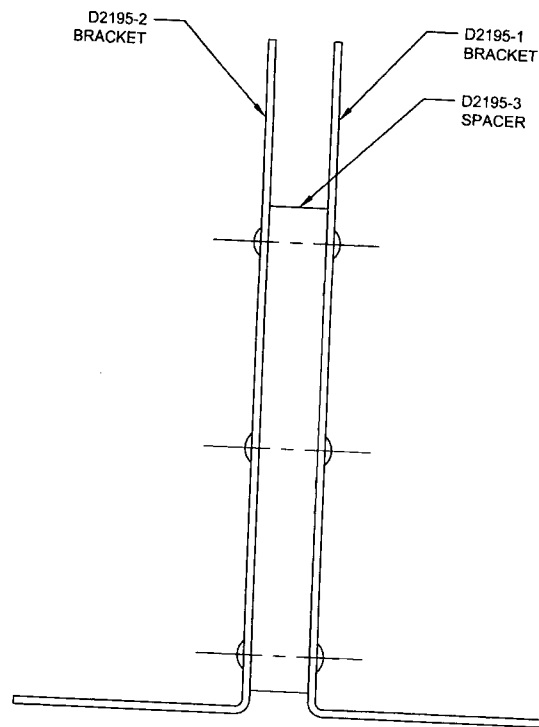
**NOTES:**

- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW; D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2195	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

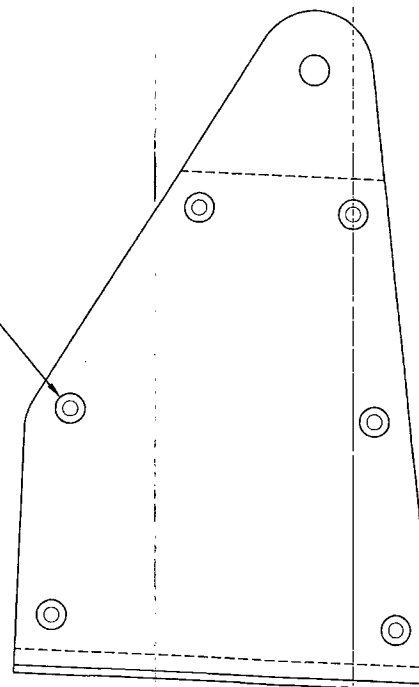
**RELEASED**  
09/01/15

*WLO 60928*



**D2195 BRACKET ASSEMBLY**

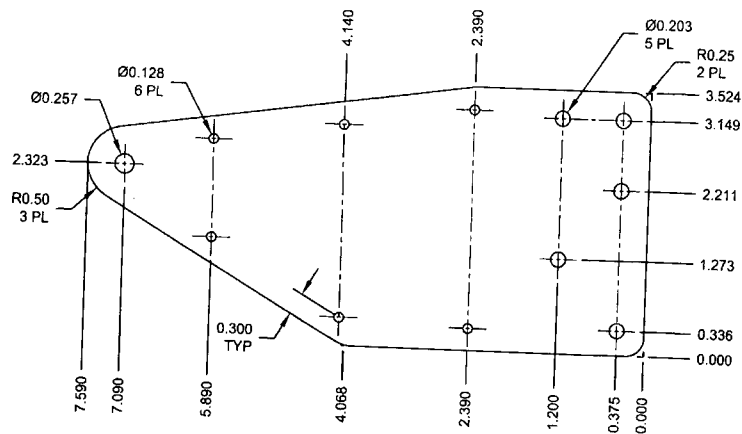
MS20470AD4-14  
RIVET  
6 PL



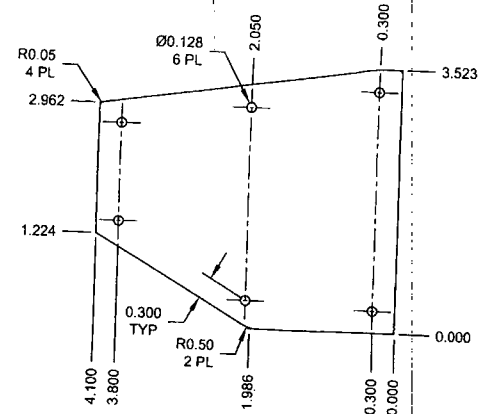
**RELEASED**  
07/01/15

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	A	DRAWING NO.
MFG. APPR.	EO	D2195
APPROVED	AM	TITLE
DE APPR.		BRACKET
DATE	08.11.25	REV. D SHEET 2 OF 3 SCALE NTS

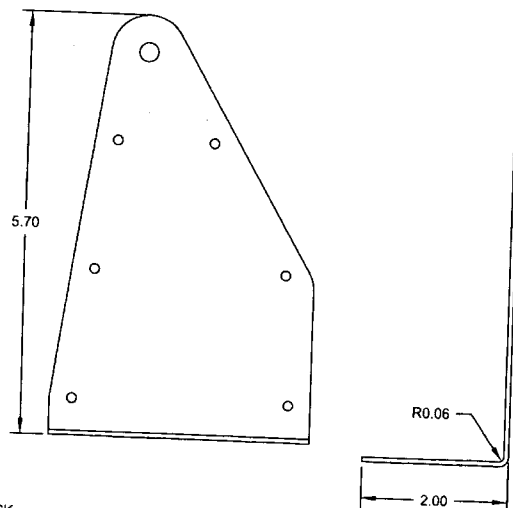
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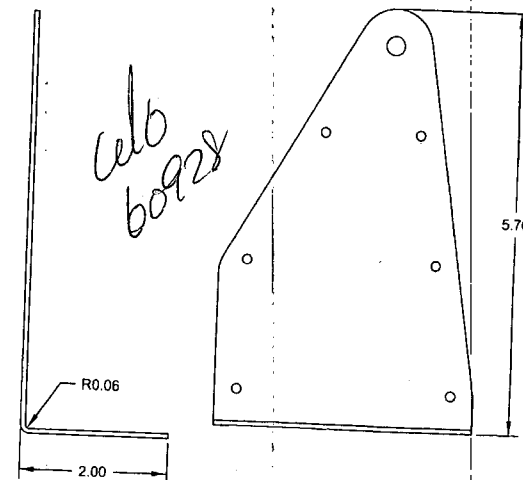
**D2195-1F BRACKET FLAT PATTERN**



**D2195-3 SPACER**



**D2195-2 BRACKET**  
MAKE FROM D2195-1F



**D2195-1 BRACKET**  
MAKE FROM D2195-1F

**NOTES:**

- 1) MATERIAL: -1 & -2: AISI 304/316 S.S. SHEET, 0.064 THICK  
PER AMS 5513 OR AMS 5524  
REF. DART SPEC M304S
- 3: 5052-H32 ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.500
- 2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

**RELEASED**  
09/01/15

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2195 TITLE BRACKET SCALE NTS
DRAWN	ALS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.11.25	

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